

Work Order ID 67366

Wednesday, March 16, 2011 1:42:11 PM



Page 1

Item ID: D3183-9

Accept



Setup Start



Revision ID:

Item Name: Cap

Stop



Start Date: 3/17/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-03-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3183	Rev C1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn D3183-9 Cap as per Folio FA388 Debur

11/24/14

60 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/24/14

60 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11/04/05

D3183-5

67329

Work Order ID 67366

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Item ID: D3183-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 3/17/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location **23p**

0.00



Packaging

Memo

0.00

Packaging

59x**11/4/5****SP****see last page**

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/5**CME****11-04-05**

Picklist Print

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Work Order ID: 67366



Parent Item: D3183-9



Parent Item Name: Cap


Start Date: 3/17/2011

Required Date: 3/31/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A 06.05.03 New issue KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELINR1.000  Delrin Round Bar 1"		Purchased			No	100	f	15.3250	0.0333	2.103158			



Handwritten signature

10/4/4

Location

Loc Qty

Loc Code

MAT

15.325

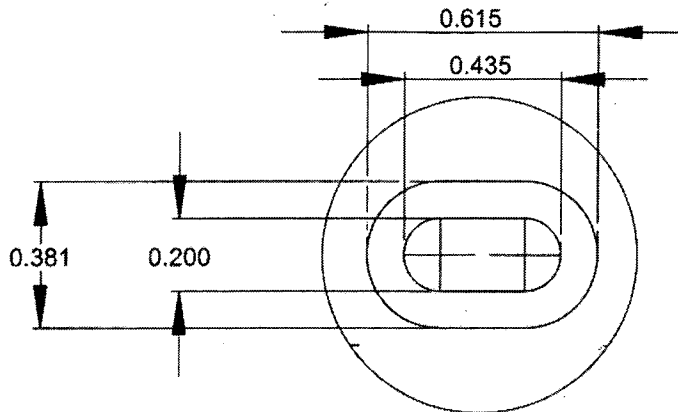
Handwritten checkmark 116266

15.325

2.1



DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

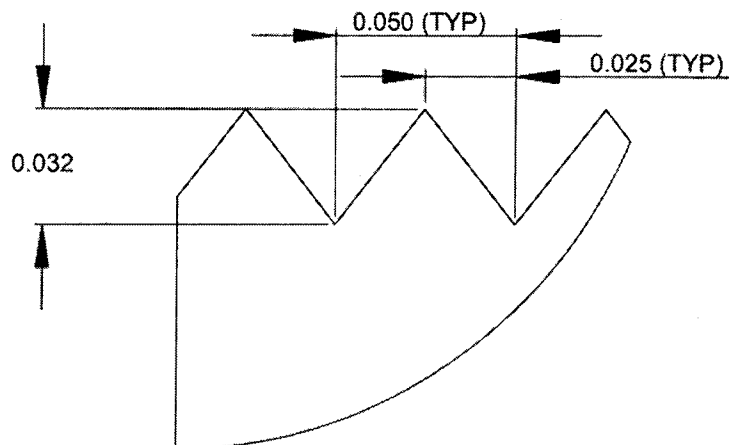


DETAIL A (2 : 1)

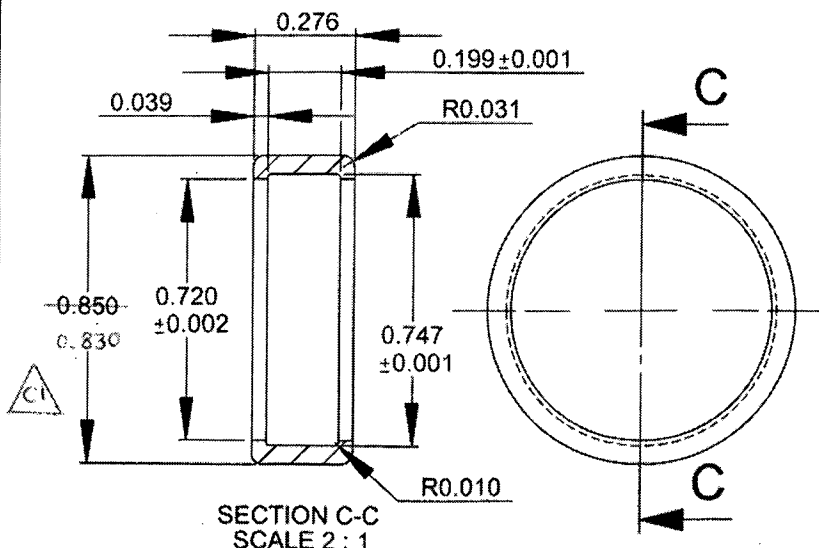
#67366

RELEASED
04-03-01

DEO ATTACHED



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O: 67366		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Took ① bearing D3183-5 #67529 x1 to assemble with D3183-9 #67366 x1 cap. I will stock as D3183-045 x1 #67366	MF	11/04/05	/			

Part No: D3183-9 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries